

Date: Thursday, 16/08/2007 7:07:20 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT CROSSTUBE
 Jot Number : 33977
 Estimate Number : 10377
 P.C. Number : *N/A* Part Number : D2890
 This Issue : 16/08/2007 S.O. No. : *N/A* Drawing Number : D2890 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 33028 Material : *N/A*
 Written By : _____ Due Date : 23/08/2007 Qty: 1 Um: Each
 Checked & Approved By : _____
 Comment : Est. D 05.03.21 Removed Bending procedures KJ/JLM

Additional Product

Jot Number:



Seq. #: Machine Or Operation: Description :

1.0 D6008180 Crosstube extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part # Description Batch
 1 D6008-180 Crosstube extrusion *B25667*

EL 7-8-27

2.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

EL 7-8-27

3.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

En A108/28 (+L)

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

N/A
used for
W/O 33984
En A108/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 7:07:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 33977

Part Number: D2890

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

used for w/o # 33984 in 07/08/28

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

handling gear/cross tube.

EL 7-8-28

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/08/24

Job Completion



U 07/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

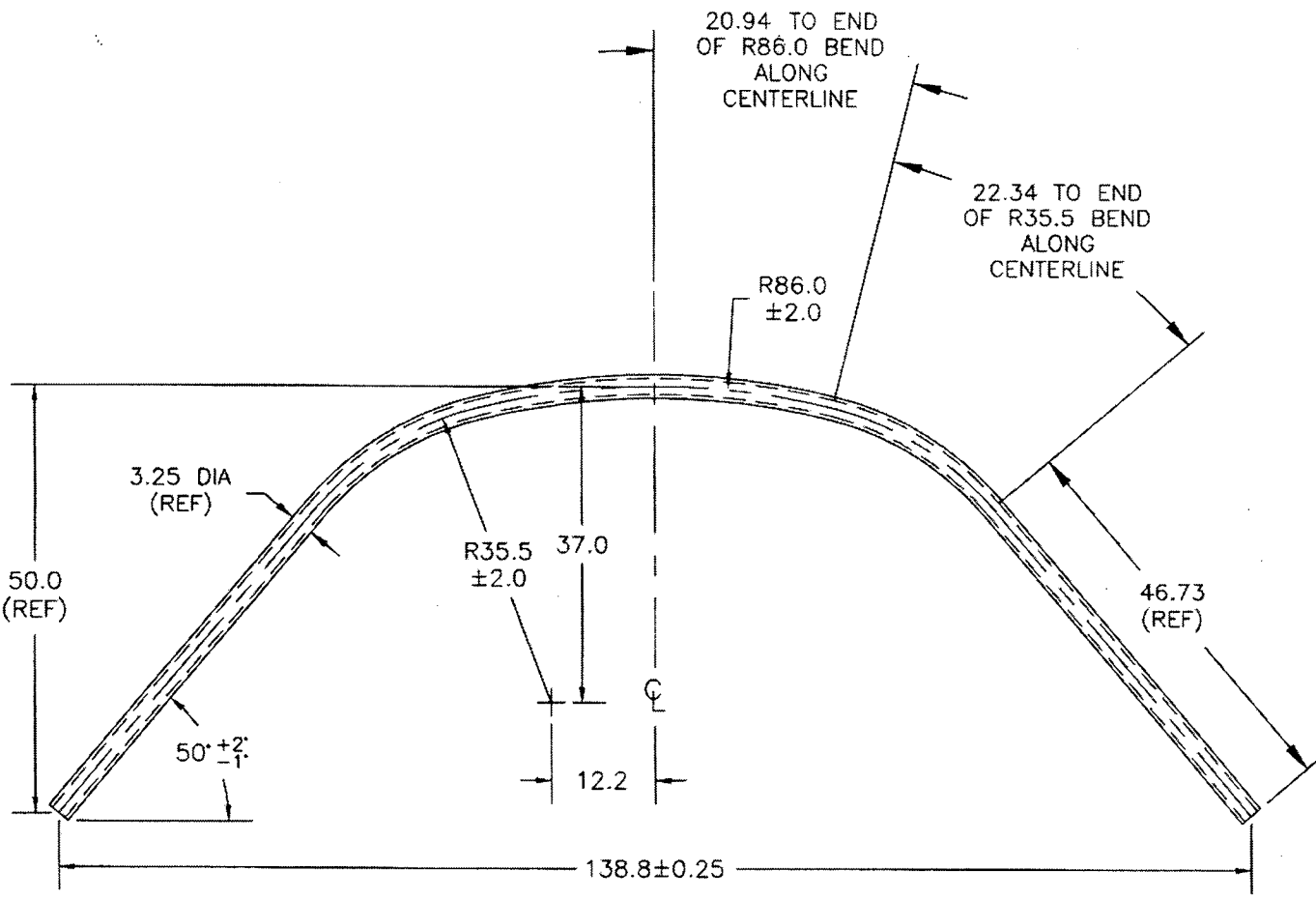
92977

DART



RELEASED
02.10.28

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE	02.10.18	DATE	02.10.18	TITLE	REV. B
				AFT CROSSTUBE	SHEET 1 OF 1
				NEW ISSUE	SCALE
				ADD TANGENT LENGTHS; CHANGE NOTES	1:20



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 (Ø3.25 OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

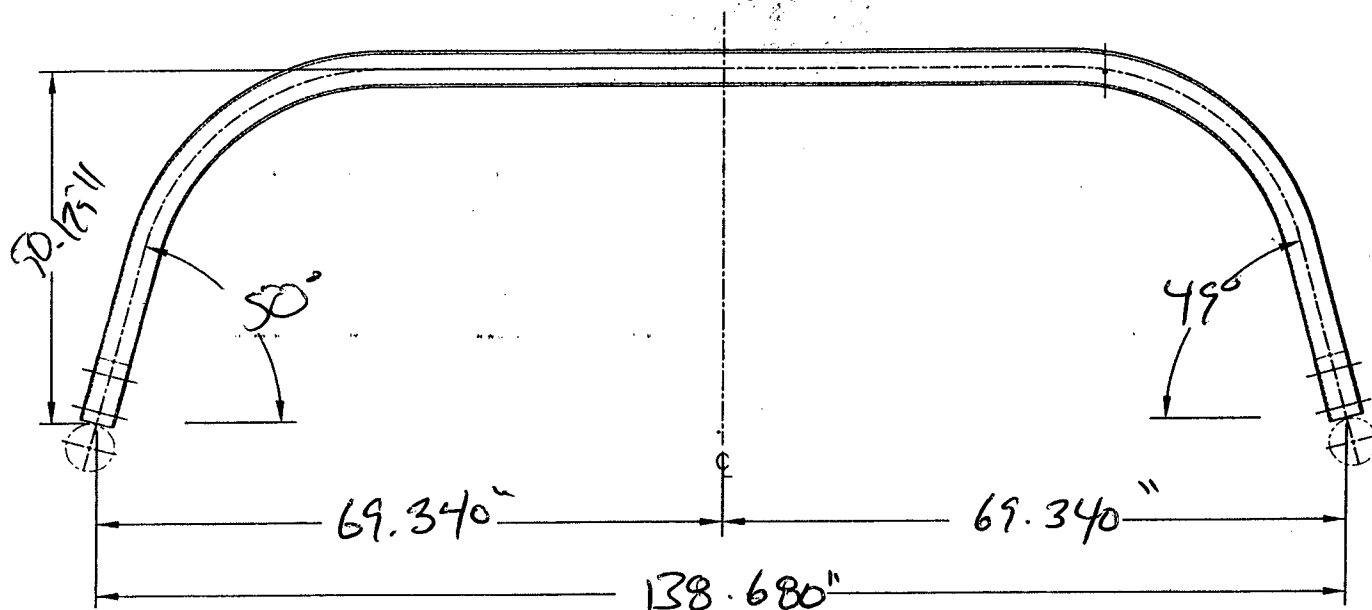
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33977 c2070828
Description: Crosstube Aft		Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1	

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

QC15 Inspection	Er
Date	11/02/20

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	